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(56) 参考文献 特願 昭54-156216 (J P, A)

特開 昭56-149045 (J P, A)

実開 昭60-118938 (J P, U)

実開 昭58-127289 (J P, U)

実開 昭61-71895 (J P, U)

(54) 【発明の名称】 断熱板及びその検査方法

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(57) 【特許請求の範囲】

【請求項1】 内部が減圧されたプラスチックフィルム容器と、このプラスチックフィルム容器内に充填された断熱材と、この断熱材中に埋設するように配置された導体あるいは半導体と、この導体あるいは半導体に接続されるときとも前記プラスチックフィルム容器外に導き出された導線とを具備してなることを特徴とする断熱板。

【請求項2】 前記導体あるいは半導体に接続された前記導線を前記プラスチックフィルム容器のヒートシール部から上記プラスチックフィルム容器外に導き出してなることを特徴とする特許請求の範囲第1項記載の断熱板。

【請求項3】 前記導体あるいは半導体に接続された前記導線の前記プラスチックフィルム容器から導き出される部分にヒートシール可能な合成樹脂材を付着させてなることを特徴とする特許請求の範囲第1項記載の断熱板。

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【請求項4】 内部が減圧されたプラスチックフィルム容器と、このプラスチックフィルム容器内に充填された断熱材と、この断熱材中に埋設するように配置された導体あるいは半導体と、この導体あるいは半導体に接続されるときとも前記プラスチックフィルム容器外に導き出された導線とを備えてなる断熱板を検査するに当たり、前記導線を介して前記導体あるいは半導体に外部から電流を流し、上記導体あるいは半導体の温度変化に対応した抵抗値変化を測定して熱伝導率を検出することを特徴とする断熱板の検査方法。

【発明の詳細な説明】

【発明の目的】

(産業上の利用分野)

本発明は、例えば冷蔵庫等に用いられる内部を減圧せしめたプラスチックフィルム容器からなる断熱板及び

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検査方法に関する。

(従来の技術)

従来、プラスチック容器中に粉体や繊維体等の断熱材を充填し内部を減圧してなる断熱板が多用されている。

この種の断熱板における熱伝導率は、その中の真空度、充填断熱材の密度、粒度、その分布、全体の厚さ、フィルム容器の構成などによって大きく変化する。

一般に、容器内の圧力が高くなると、その熱伝導率は大きくなり断熱性能は低下する。そのため断熱板の断熱性能検定は、一般に、断熱板容器内の圧力測定結果に基づいている。通常内部圧力を測定するにはこの断熱板をさらに真空容器に入れ、断熱板周辺の圧力を下げ内部圧力とつりあい、その断熱板容器のプラスチックフィルムが膨張してきたときの圧力を圧力計で測定し、それをもって内部圧力としている。ところが、これをおこなうためには断熱板全体をさらに真空容器に入れる必要があり、真空引き等手間がかかり、高真空の場合その変位は小さく、これを精度よく検出するのは非常に困難なものであった。また、前述の如く、断熱板の熱伝導率は断熱板容器内の圧力ばかりか、充填材の密度等によっても変化する。断熱板容器内の圧力測定は断熱板の熱伝導率に關与する1つのデータを得ているに過ぎないといえる。したがって、従来の検定手法は、断熱板の断熱性能を正しく評価するには不十分なものであった。

(発明が解決しようとする問題点)

本発明は、上記の断熱板の断熱性能の検査に煩雑な手間を要しかつ高精度の検査が困難であるという問題点に鑑みてなされたもので、断熱性能の検査を容易かつ高精度に行い得る断熱板及びその検査方法を提供することを

目的とする。

[発明の構成]

(問題を解決するための手段)

本発明は上記目的を達成するために、内部が減圧されたプラスチックフィルム容器内に断熱材が充填され、この断熱材内部に導体あるいは半導体を埋め込み、この導体あるいは半導体に接続された導線をプラスチックフィルム容器外に導き出した断熱板、及びこの断熱板の導体あるいは半導体に電流を流し、この導体あるいは半導体の温度変化にもとづく抵抗値変化を測定して熱伝導率を検出する断熱板の検査方法である。

(作用)

上記手段のように、断熱材内部に導体あるいは半導体を埋め込み、この導体あるいは半導体に電流を流したときの温度上昇度に対応した抵抗値変化を測定して、熱伝導率を検出できるようにしたものである。すなわち、導体あるいは半導体に電流を流したとき、これらが温度上昇するときの勾配、換言するとこれらの抵抗値変化の勾配は、これらが位置している場の真空度、充填断熱材の密度、粒度、その分布、全体の厚さ、フィルム容器の構

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成など、つまり断熱板の熱伝導率によって変化する。したがって、断熱材中に導体あるいは半導体を埋め込んだ構成の断熱板であると、この断熱板の断熱性能に影響する全ての因子を含んだ真の熱伝導率を簡単に、かつ高精度に検査できることになる。

(実施例)

以下図面を参照して本発明の実施例を詳細に説明する。

第1図及び第2図は本発明の断熱板の一実施例を示し、例えばポリエステル等からなるプラスチックフィルム容器3は周辺部分のヒールシール部4により密封される。このフィルム容器3内には通気性のある不織布からなる内袋2が入れられ、この内袋2内には粉体のパーティライトからなる断熱材1が充填されている。この断熱材1の厚さ方向のほぼ中央部分には例えば長さ20mm、太さ0.1mmφのタングステンの導体6が埋設され、この導体6の両端部には例えば厚さ0.1mm、幅2mmの銅よりなる扁平形の導線5が接続され、この導線5はフィルム容器3の外部へ導き出される。前記フィルム容器3の内部は1Torr前後に減圧され、この減圧時に飛散しないように断熱材1は内袋2に入られている。

すなわち、導線5に一定の電流を流すと、導体6は加熱されて温度が上昇してゆく。ところで、この導体6に使用されているタングステン線は第3図に示すように、温度と抵抗値R(Ω)がある温度範囲ではほぼ直線的な関係にある。すなわち、タングステン線の抵抗値と温度との関係を予め検査しておけば、抵抗値からそのときの温度がわかる。この検査線はタングステンの抵抗の温度係数が既知であり、容易に求まる。ところで、このタングステン線の温度上昇度を支配するのは、この導体6に流される電力量と、このまわりの断熱材1の断熱性すなわち熱伝導率である。つまり、第4図のAに示すように熱伝導率λの小さいときには、熱は逃げにくいため、急激な温度上昇がみられ、抵抗値Rが急に大きくなる。逆に、第4図のBに示すように熱伝導率λが大きいときには、温度は上がりやすく、抵抗値Rの変化は小さくなる。このことから、この導体6に一定の電流を流すための電圧の時間変化を測定することにより、断熱性能に影響する真空度等の全ての因子を含んだ真の熱伝導率λを検量線から検出することができる。

次に、導体6の抵抗値変化を測定するには第5図に示すように、導体6を素子として標準抵抗R1、R2、R3とブリッジ回路を構成し、このブリッジ回路に定電圧電源Eより定電圧V<sub>0</sub>を印加すると、導体6の温度上昇にともなう抵抗値変化がおこる。そこで、導体6の降下電圧V<sub>d</sub>と抵抗R<sub>0</sub>の降下電圧V<sub>d</sub>との差電圧V(1)を電圧計Vで測定する。

このとき、R1、R2、R3は不変抵抗のため、特にR1とR2に印加される電圧は時間に対して不変であり、V<sub>0</sub>は次の式で求まる。

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$$V_3 = (R_2 / (R_1 + R_2)) \times V_0 \quad * * \text{このため、} V_X \text{は}$$

$$\begin{aligned} V_X &= V_2 + V(t) \\ &= \frac{R_2}{R_1 + R_2} \cdot V_0 + V(t) \end{aligned}$$

また、 $R_3$ 、導体6を流れる電流は

$$(V_3 = V_0 - V_X)$$

$$I_3 = V_3 / R_3 = (V_0 - V_X) / R_3$$

より算出でき、導体6の抵抗値 $R(t)$ が

$$R(t) = V_X / \{ (V_0 - V_X) / R_3 \}$$

の関係から算出できる。

すなわち、導体の温度と抵抗の関係より、各時間毎の $R(t)$ より温度を算出し、時間の対数と温度の直線関係を示す範囲の傾きから、熱伝導率を求めることができる。このとき、あらかじめ、真空度と熱伝導率の関係を調査しておけば、真空度も推測することが可能である。

上記実施例によれば次のような効果がある。

(1) 真空断熱板を改めて真空槽に入れることなく、その導体に電流を流し、その抵抗の時間変化を観測するだけで、その熱伝導率が測定でき、その断熱性能を検査することができる。

(2) その検査に要する時間は数10秒程度で済ませて短時間に検査できる。

(3) 真空容器に入れられないため、その検査を連続的に行うことができる。

(4) 導線はヒートシール部分にはさみ込むだけで押入でき、組込みはきわめて容易である。また導線は平坦であるためこれをはさんでのヒートシールは容易である。

(5) この断熱板を組込んでしまった後でも、その測定値から断熱性を測定することができ、また断熱性の寿命を推定することもできる。

なお、第6図は導線5と導体6において、フィルム容器3のフィルムにヒートシールされる部分に予め、ヒートシール可能な合成樹脂材例えばポリエチレンからなるフィルム7を導線5の両面に付着させたもので、このことによりヒートシールが確実になり、かつ導線5と導体6をあらかじめユニット化して、断熱板に組込むとき取り扱いしやすいようにしたものである。

また本発明は上記実施例に示すような粉末からなる断熱材に限らず、ガラス繊維のような繊維体でもよく、また導体6はタングステン線ではなく、白金などの金属、または半導体でもよい。ただし半導体では抵抗の温度特

性は導体のそれとは逆になる。また上記実施例では導体6の温度変化をその抵抗の変化から求めたが、第7図のようにここに熱電対やサーミスタ等の感熱素子8を直接つけて温度測定を行なう方法でも良い。また導体6は直線状におかれなくともらせん状等のようにして長くして、より抵抗の変化を大きくしても良い。また、ヒートシール部分で導線5と第8図のようにつづら折り状にまげてヒートシール部分内の長さを長くして、ガスバリア性を増加させても良い。

【発明の効果】

以上述べたように本発明によれば、断熱材内部に導体あるいは半導体を埋めこみ、この導体あるいは半導体に断熱材外部から電流を流せるようにしたことにより、その通電中の温度変化からその熱伝導率を測定することができるようになったので、次の効果がある。

(1) 従来非常に手間のかかった真空断熱板の性能検査の工程が導体あるいは半導体に電流を流し、その導体あるいは半導体の温度変化をみるだけで、短時間にかつ連続的にその断熱性能を検査することができ、検査工程の大幅な簡略化が可能である。

(2) 真空度が高く熱伝導率が小さい場合でも、より精度よく測定が可能である。

(3) この導体あるいは半導体を埋め込むことにより、断熱板の断熱性能には全く影響なく、従来通り使用することができる。

(4) この導体あるいは半導体の組み込みはきわめて容易である。

【図面の簡単な説明】

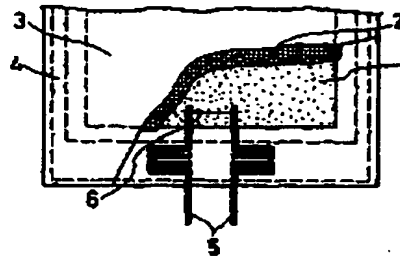
第1図は本発明の一実施例を示す断面図、第2図は同じく一部切欠正面図、第3図は導体の抵抗と温度の関係を示す図、第4図は本発明に係る導体の時間 $\log t$ -抵抗値 $R$ 特性の一例を示す図、第5図は本発明に係る導体の抵抗値測定回路の一例を示す図、第6図～第8図は本発明の他の実施例を示す構成図である。

1……断熱材、2……内袋、3……フィルム容器、5……導線、6……導体、7……ヒートシール可能なポリエチレンからなるフィルム、8……感熱素子。

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【第8図】



## \* NOTICES \*

JP PAT. 2610250

English translation

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CLAIMS

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## (57) [Claim]

[Claim 1] The heat insulation plate characterized by coming to provide the lead wire drawn out of the aforementioned plastics film container while it connected with the plastics film container with which the interior was decompressed, the heat insulator with which it filled up in this plastics film container, the conductor or semiconductor arranged so that it may be buried into this heat insulator, and this conductor or semiconductor.

[Claim 2] The heat insulation plate given in the 1st term of a claim characterized by coming to draw the aforementioned lead wire connected to the aforementioned conductor or the semiconductor out of the above-mentioned plastics film container from the heat-sealing section of the aforementioned plastics film container.

[Claim 3] The heat insulation plate given in the 1st term of a claim characterized by making the synthetic-resin material which can be heat sealed into the fraction drawn from the aforementioned plastics film container of the aforementioned lead wire connected to the aforementioned conductor or the semiconductor come to adhere.

[Claim 4] The plastics film container with which the interior was decompressed, and the heat insulator with which it filled up in this plastics film container, In inspecting the heat insulation plate which comes to have the lead wire drawn out of the aforementioned plastics film container while it connected with the conductor or semiconductor arranged so that it may be buried into this heat insulator, and this conductor or semiconductor The check technique of the heat insulation plate characterized by passing a current from the exterior to the aforementioned conductor or a semiconductor through the aforementioned lead wire, measuring the resistance change corresponding to the temperature change of the above-mentioned conductor or a semiconductor, and detecting thermal conductivity.

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[Translation done.]

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DESCRIPTION OF DRAWINGS

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[An easy explanation of a drawing]

The cross section showing [ 1 ] one example of this invention and a view 2 are the same, and notching front view, drawing showing [ 3 ] resistance of a conductor and the relation of temperature, drawing showing an example of the time log t-resistance R property of the conductor which a view 4 requires for this invention, drawing showing an example of the resistance measuring circuit of the conductor which a view 5 requires for this invention, and a view 6 - an octavus view are block diagrams showing other examples of this invention in part 1 [ .. A film container, 5 / .. Lead wire, 6 / .. A conductor, 7 / .. The film which consists of polyethylene which can be heat sealed, 8 / .. Sensible-heat element ] .... A heat insulator, 2 .. An inside bag, 3

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[Translation done.]

## \* NOTICES \*

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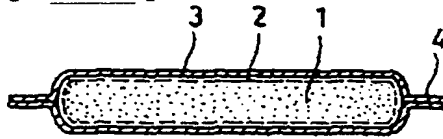
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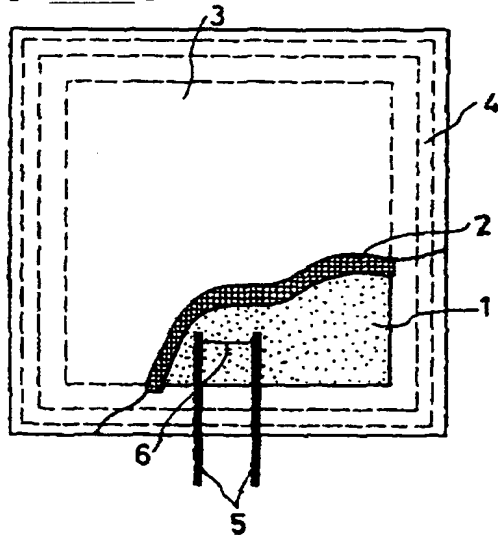
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## DRAWINGS

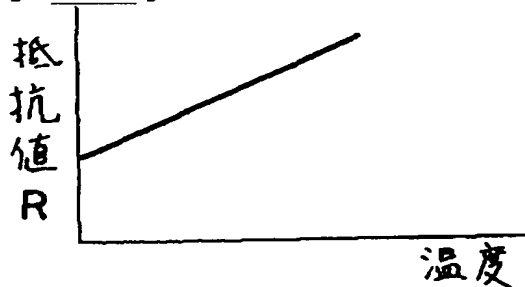
[A view 1 ]



[A view 2 ]

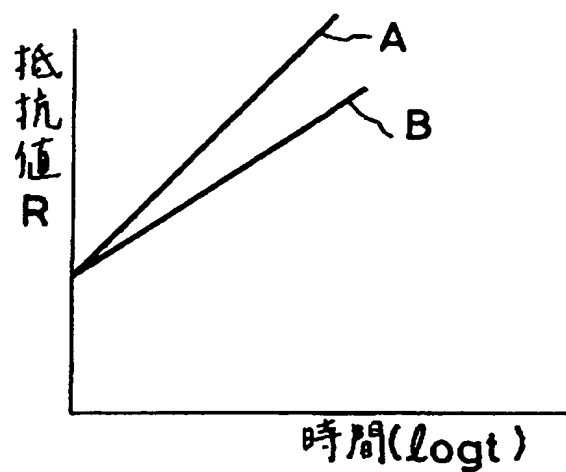


[A view 3 ]

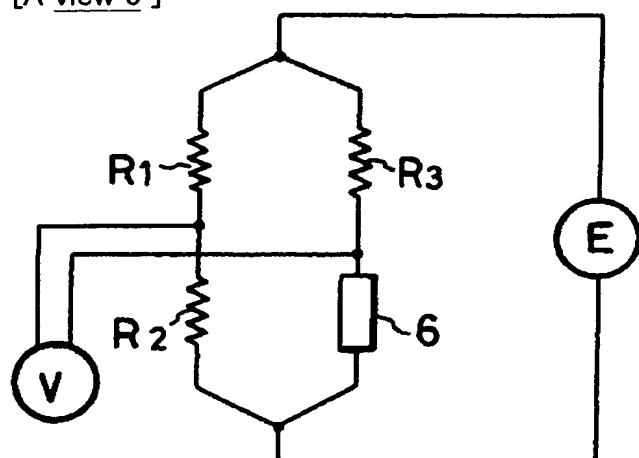


[A view 4 ]

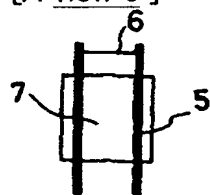




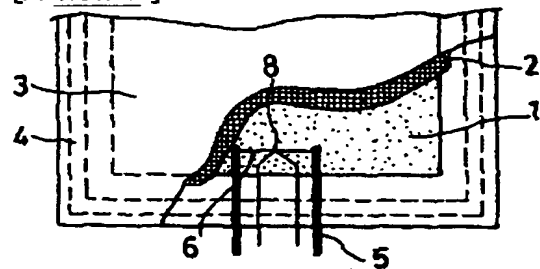
[A view 5]



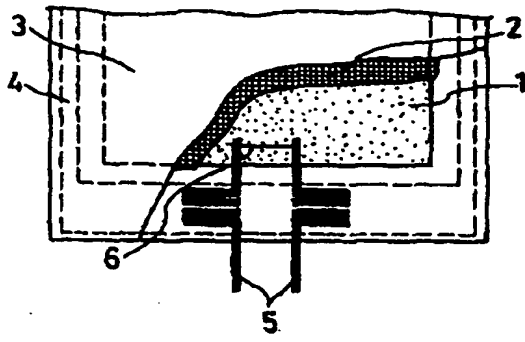
[A view 6]



[A view 7]



[An octavus view]



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[Translation done.]

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## DETAILED DESCRIPTION

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[Detailed description]

[The purpose of invention]

(Field of the Invention)

this invention relates to the heat insulation plate and the check technique of consisting of a plastics film container which made the interior used for cold storage etc. decompress.

(Prior art)

Conventionally, it is filled up with heat insulators, such as fine particles and the fiber field, into a plastics container, and the heat insulation plate which comes to decompress the interior is used abundantly.

The thermal conductivity in this kind of heat insulation plate changes with the configurations of the degree of vacuum in it, the density of a restoration heat insulator, grain size, its distribution, the whole thickness, and a film container etc. a lot.

Generally, if the pressure in a container becomes high, the thermal conductivity will become large and adiathermancy ability will fall. Therefore, generally adiathermancy ability certification of a heat insulation plate is based on the pressure-survey result in a heat-insulation-plate container. Usually, for measuring an internal pressure, this heat insulation plate is further put in into a vacuum housing, a pressure when the pressure of the heat-insulation-plate circumference is lowered and the plastics film of an internal pressure, the balance, and its heat-insulation-plate container has expanded is measured with a pressure gage, and it is considering as the internal pressure with it. However, when it is necessary to put the whole heat insulation plate into a vacuum housing further in order to perform this, and time, such as vacuum length, was taken and it was a high vacuum, the variation rate was small, and it was very difficult to detect this with a sufficient precision. Moreover, since the thermal conductivity of a heat insulation plate changes with the densities of about [ the pressure in a heat-insulation-plate container ] and a filler etc. like the above-mentioned, it can be said that the pressure survey in a heat-insulation-plate container has obtained one data which participates in the thermal conductivity of a heat insulation plate. Therefore, the conventional certification technique was inadequate for evaluating the adiathermancy ability of a heat insulation plate correctly.

(Trouble which invention tends to solve)

A check of the adiathermancy ability of the above-mentioned heat insulation plate takes complicated time, and the highly precise check was made in view of the trouble of being difficult, and this invention aims at offering the heat insulation plate which can inspect adiathermancy ability easily and with high precision, and its check technique.

[The configuration of invention]

(Means for solving a problem)

the heat insulation plate which drew the lead wire which it fills up with a heat insulator in the plastics film container with which the interior was decompressed, embeds a conductor or a semiconductor to this interior of a heat insulator, and was connected to this conductor or semiconductor out of the plastics film container in order that this invention might attain the above-mentioned purpose and the conductor of this heat insulation plate, or a semiconductor -- a current -- passing -- the temperature change of this conductor or a semiconductor -- a basis

-- it is the check technique of the heat insulation plate which measures \*\*\*\* resistance change (Operation)

Like the above-mentioned means, a conductor or a semiconductor is embedded to the interior of a heat insulator, the resistance change corresponding to the degree of temperature rise when passing a current to this conductor or semiconductor is measured, and it enables it to detect thermal conductivity. That is, when a current is passed to a conductor or a semiconductor, if it puts in another way, the inclination of these resistance change will change with the thermal conductivity of heat insulation plates, such as a configuration of inclination in case these carry out a temperature rise, the degree of vacuum of the place in which these are located, the density of a restoration heat insulator, grain size, its distribution, the whole thickness, and a film container, that is,. Therefore, when it is the heat insulation plate of a configuration of having embedded the conductor or the semiconductor into the heat insulator, the true thermal conductivity containing all the factors that influence the adiathermancy ability of this heat insulation plate can be inspected simply and with high precision.

(Example)

With reference to a drawing, the example of this invention is explained in detail below.

The plastics film container 3 which a view 1 and the 2nd view show one example of the heat insulation plate of this invention, for example, consists of polyester etc. is sealed by the heel seal section 4 of a circumference fraction. It fills up with the heat insulator 1 which is put into the inner bag 2 which consists of a nonwoven fabric which has permeability in this film container 3, among these consists of a pearlite of fine particles in a bag 2. the thickness orientation of this heat insulator 1 -- the conductor 6 of the tungsten of the length of 20mm and 0.1mm [ of sizes ] phi is mostly laid under a part for a center section, the lead wire 5 of a \*\*\*\* form which consists of copper with 0.1mm [ in thickness ] and a width of face of 2mm is connected to the both ends of this conductor 6, and this lead wire 5 is drawn in the exterior of the film container 3 The interior of the aforementioned film container 3 is decompressed before and behind 1Torr, and the heat insulator 1 is contained in the inner bag 2 so that it may not disperse at the time of this reduced pressure.

That is, if a fixed current is passed to lead wire 5, a conductor 6 will be heated and temperature will rise. By the way, the tungsten line currently used for this conductor 6 is in an almost linear relation in the temperature requirement with temperature and resistance  $R$  ( $\omega$ ), as shown in a view 3 . That is, if the measuring of the relation between the resistance of a tungsten line and temperature is carried out beforehand, resistance shows the temperature at that time. The temperature resistance coefficient of a tungsten is known and this calibration curve can be found easily. By the way, the adiathermancy of the electric energy passed by this conductor 6 and the heat insulator 1 around this, i.e., thermal conductivity  $\lambda$ , governs the degree of temperature rise of this tungsten line. That is, at the time of the parvus of thermal conductivity  $\lambda$ , as shown in A of the 4th view , in order that heat may seldom escape, a rapid temperature rise is seen and resistance  $R$  becomes large suddenly. Conversely, as shown in B of the 4th view , when large, thermal conductivity  $\lambda$  seldom goes up temperature, and, as for change of resistance  $R$ , becomes small. True heat conductivity  $\lambda$  containing all factors, such as a degree of vacuum which influences adiathermancy ability, is detectable from a calibration curve by measuring time change of the voltage for passing a fixed current from this to this conductor 6.

Next, if standard resistances  $R_1$ ,  $R_2$ , and  $R_3$  and a bridge circuit are constituted, using a conductor 6 as an element as shown in a view 5 , for measuring resistance change of a conductor 6 and a constant voltage  $V_0$  is impressed to this bridge circuit from constant-voltage-power-supply  $E$ , the resistance change accompanied by the temperature rise of a conductor 6 will start. Then, difference voltage  $V(t)$  of the descent voltage  $V_X$  of a conductor 6 and the descent voltage  $V_2$  of resistance  $R_2$  is measured by voltmeter  $V$ .

At this time, the voltage on which  $R_1$ ,  $R_2$ , and especially  $R_3$  are impressed to  $R_1$  and  $R_2$  for constant resistance is eternal to time, and  $V_2$  can be found by the following formula.

$$V_x = V_2 + V(t)$$

$$= \frac{R_2}{R_1 + R_2} \cdot V_0 + V(t)$$

$V_2 = [R_2 / (R_1 + R_2)] \times V_0$  For this reason, it is  $V_x$ .

Moreover, the current which flows  $R_3$  and the conductor 6 ( $V_3 = V_0 - V_x$ )

$I_2 = V_3 / R_3 = (V_0 - V_x) / R_3$  — computable — resistance  $R(t)$  of a conductor 6 —  $R(t) = V_x / [(V_0 - V_x) / R_3]$

It is computable from \*\*\*\*\*.

That is, from the temperature of a conductor, and the relation of resistance, temperature can be computed from  $R(t)$  for every time, and it can ask for the inclination of the domain which shows the straight-line relation between the logarithm of time, and temperature to thermal conductivity. If the relation between a degree of vacuum and thermal conductivity is beforehand investigated at this time, it is possible to also guess a degree of vacuum.

According to the above-mentioned example, there are the following effects.

- (1) Without putting a vacuum-insulation plate into a vacuum tub anew, a current is passed to the conductor, only by observing time change of the resistance, the thermal conductivity  $\lambda$  can be measured and the adiathermancy ability can be inspected.
- (2) The time which the check takes can be extremely inspected in about several 10 seconds for a short time.
- (3) Since it cannot go into a vacuum housing, the check can be conducted continuously.
- (4) Lead wire can carry out a closet only by inserting in a heat-sealing fraction, and the nest is very easy. Moreover, since lead wire is flat, heat sealing which sandwiches this is easy.
- (5) After having incorporated this heat insulation plate, adiathermancy can be measured from the measured value, and the life of adiathermancy can also be presumed.

In addition, when including in a heat insulation plate, it tends to deal with and be made for the film 7 which becomes the fraction heat sealed by the film of the film container 3 beforehand in lead wire 5 and the conductor 6, the synthetic-resin material, for example, the polyethylene, which can be heat sealed, to have been made to adhere to both sides of lead wire 5, and for heat sealing to become certain by this, and for the 6th view to unit-ize lead wire 5 and the conductor 6 beforehand, and to carry out them.

Moreover, the fiber field not only like the heat insulator which consists of the powder which is shown in the above-mentioned example but a glass fiber is sufficient as this invention, and metals, such as not a tungsten line but platinum, or a semiconductor is sufficient as a conductor 6. However, with a semiconductor, the temperature characteristic of resistance becomes contrary to it of a conductor. Moreover, although the temperature change of a conductor 6 was searched for from change of the resistance in the above-mentioned example, the technique of attaching the sensible-heat elements 8, such as a thermocouple and a thermistor, here directly as shown in a view 7, and performing a thermometry may be used. Moreover, a conductor 6 may be carried out like a spiral grade also in the shape of a straight line, may be lengthened, and may enlarge change of resistance more. Moreover, in a heat-sealing fraction, as shown in lead wire 5 and an octavus view, it may bend in the shape of a \*\* face chip box, and the length in a heat-sealing fraction may be lengthened, and gas barrier nature may be made to increase.

[Effect of the invention]

Like, according to this invention, a conductor or a semiconductor is embedded to the interior of a heat insulator, and since the thermal conductivity can be measured now from the temperature change in the \*\*\*\* by [ which was described above ] having enabled it to pass a current from the heat insulator exterior to this conductor or semiconductor, there is the following effect.

- (1) the process of the performance verification of the vacuum-insulation plate which time applied very much conventionally — a conductor or a semiconductor — a current — passing — only seeing the temperature change of the conductor or a semiconductor — it is — a short time — and the adiathermancy ability can be inspected continuously and large simplification of an

inspection process is possible

(2) A degree of vacuum can measure with a precision high and more sufficient [ thermal conductivity ] also at a parvus case.

(3) By embedding this conductor or semiconductor, it can be used for the adiathermancy ability of a heat insulation plate as usual uninfluent at all.

(4) Inclusion of this conductor or a semiconductor is very easy.

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[Translation done.]